

Date: Thursday, 6/15/2006 1:41:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING
Job Number	: 27562		
Estimate Number	: 10336		
P.O. Number	: <i>NIA</i>	Part Number	: D2807
This Issue	: 6/15/2006	S.O. No.	: <i>NIA</i>
Prsht Rev.	: NC	Drawing Number	: D2807 REV C
First Issue	: <i>NIA</i>	Project Number	: N/A
Previous Run	: 27151	Drawing Revision	: C
		Material	: <i>NIA</i>
Written By	: <i>See 1st Comment Below</i>	Due Date	: 7/15/2006
Checked & Approved By	: <i>JA 06.06.15</i>	Qty:	50 Um: Each
Comment	: Est: D 05.06.21 Removed painting; Changed supplier KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *1515**C Loc 119106**(50)*

Order as per Dwg D2807

Possible supplier: ArvinMeritor Motion Control Systems

Material release note is required

2.0

SXF6S6050080S6L115N

GAS SPRING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

SUPPORT PROP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

*PA**6/7/17**(50)*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

June 18 (50)

5.0

D28073

Lug




Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

2 D2807-3 Lug Batch: *B27583*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/02

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:41:51 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 27562

Part Number: D2807

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install lugs and crimp using DT8791 crimp jig:

SAD 06:07:31 (50)

2-Remove lettering and logo with wash and wipe.

SAD 06:07:20 (50)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SAD 06/08/01

(30)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(50)
SAD 06/08/02

Job Completion



CL 06/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

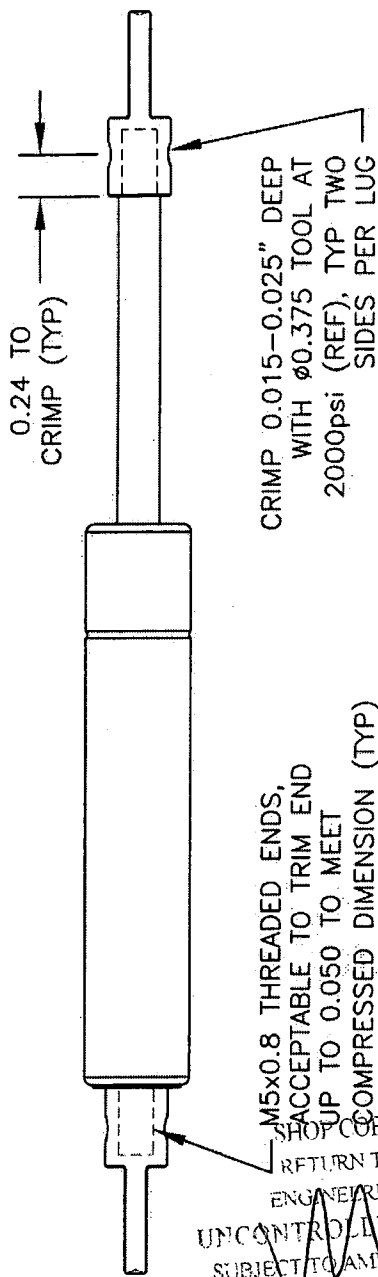
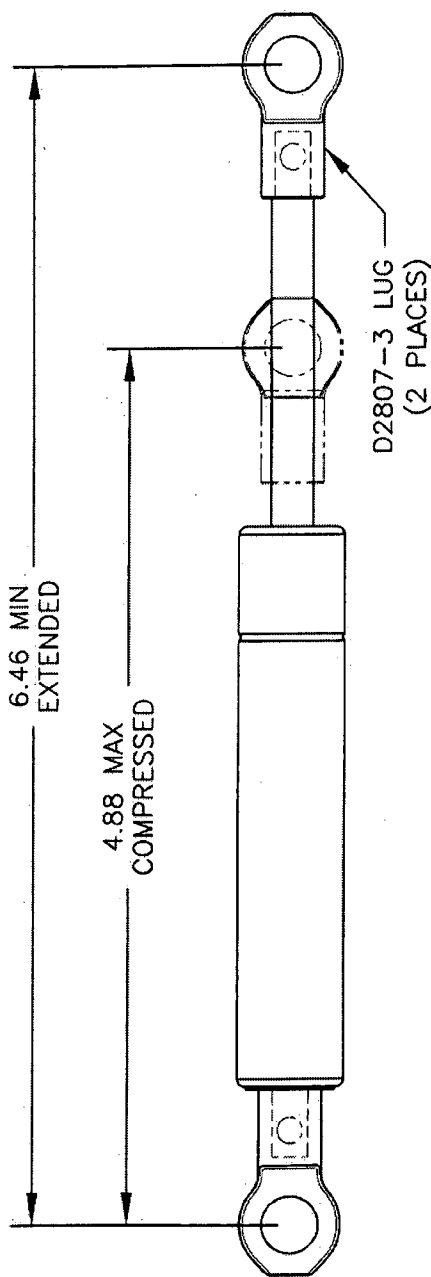
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D2807
				REV. C
DATE	05.05.25	TITLE	GAS SPRING	SHEET 1 OF 2
				SCALE 1:1
A	00.11.03	NEW ISSUE		
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		

RELEASED
#45.06.16



M5x0.8 THREADED ENDS,
ACCEPTABLE TO TRIM END
UP TO 0.050 TO MEET
COMPRESSED DIMENSION (TYP)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

D2807 GAS SPRING

- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

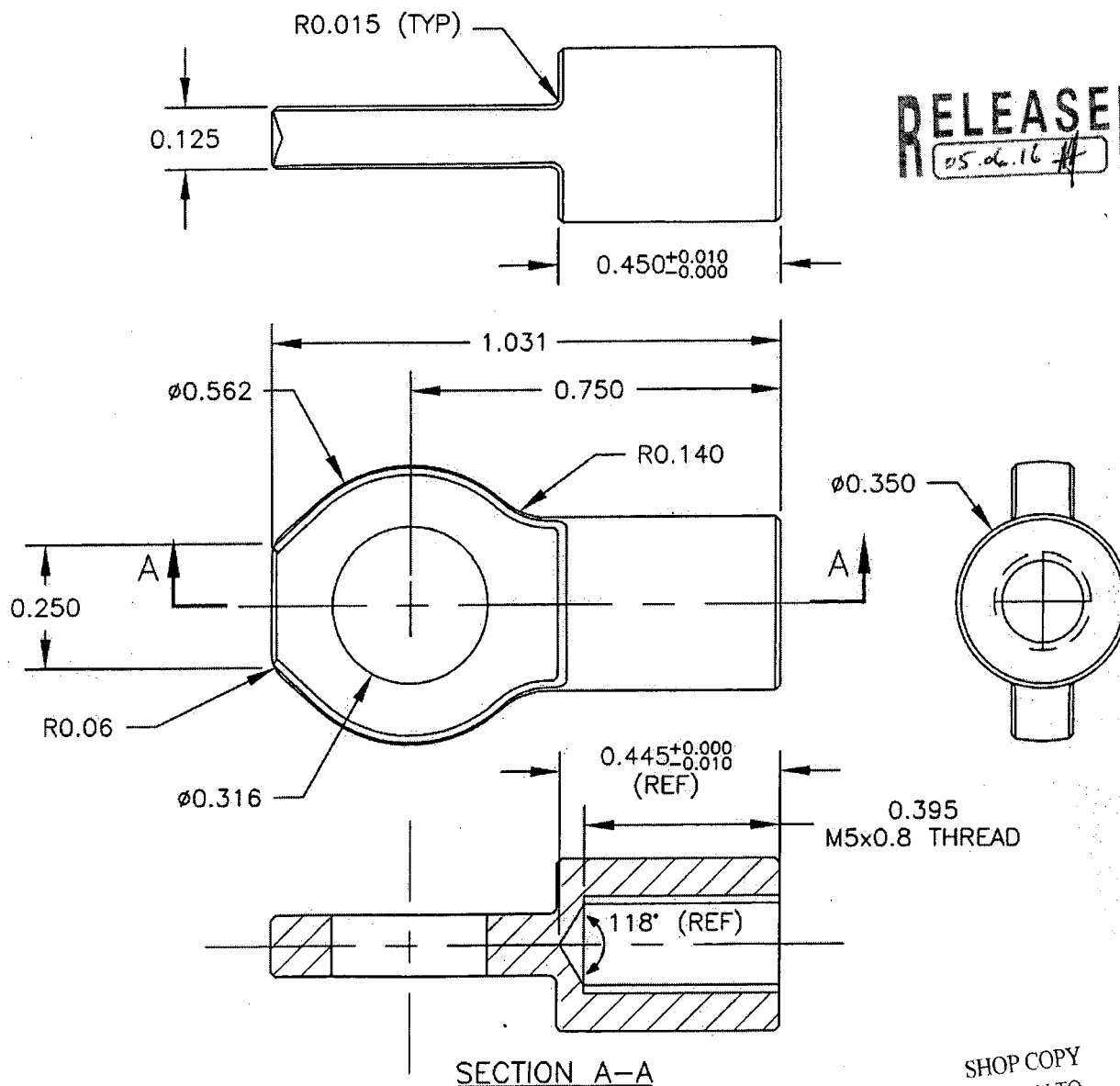
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WORK ORDER
NO. 27562

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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RETURN TO
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DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7
CANADA

DART AEROSPACE LTD

FEDEX

DATE
100706

A/C No. :
20111

AREA
46

CUSTOMER REF. No.
F0 00001515

V.A.T. REGISTRATION No. GB 738 8577 71

W ORDER
NUMBER

[illegible]

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Main Fax: +44 (0)116 274 3620
E-mail - info.amcl@arvinmeritor.com
Website: www.camloc.com

YOUR ORDER WAS PACKED BY _____

Certified that the whole of the supplies detailed hereon have been inspected and tested and unless otherwise stated conform in all respects with the contract/surchase order.

SIGNED _____

SIGNED